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D3210-1

Job Sheet 213320



Part No: D3210-1

Job Qty: 6 pcs

Part Name: Doubler For Interior Window -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/22/20

Job Tracking No:

Due Date: 10/26/20

Created By: Marie Lajeunesse

Type: ~~Stock~~ *Salp*

Description: SIOP

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now On Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		10/24/20	0.17	1.44	Waterjet - Flow		<i>on 20/10/05</i>
120	QC 8	6 pcs		10/24/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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				QC 8 - 82	
150 Handfinish - 1-1 Chemical-B4B	6 pcs	10/24/20	0.00 0.41	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	6 pcs	10/24/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	

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Handwritten date and price: 20-10-9 \$3.86

					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
160	Powdercoat - 4 Black Sand - B4B	6 pcs	10/26/20	0.00 0.19	Powdercoat - 1 - B4B	
	<i>M/S 440.</i>				Powdercoat - 2 - B4B	
	<i>START: 10:25.</i>				Powdercoat - 3 - B4B	<i>20-10-9.</i>
	<i>O.V.T: 320°</i>				Powdercoat - 4 - B4B	
	<i>FINISH: 11:55.</i>				Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
170	QC 3	6 pcs	10/26/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	<i>DET 09 2020</i>
					QC 3 - 19	<i>40</i>
					QC 3 - 43	<i>39</i>
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
180	Packaging 3-1 - Stock - B4B	6 pcs	10/26/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	<i>DAS</i>
					Packaging 3 - 6 - B4B	<i>28</i>
						<i>9-89</i>

				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				Packaging 3 - 37 - B4B					
				190 QC 21 - SA	6 pcs	10/26/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-29 OCT 13 2020
								QC 21 - SA - 70	
								QC 21 - SA - 9	
								QC 21 - SA - 77	
								QC 21 - SA - 28	
				Part Op 100 - 1-Cut as per Dwg D3210					
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Descriptions: **120** - (QC8- Inspect parts - second check)
150 - (Chemical Conversion Coat per QSI005 4.1)
155 - (QC7-Inspect Chemical Conversion Coat)
160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location:_____)
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	10.2000 sf (1.7 ea)	100-Waterjet - Flow - 1	S10799/S137552/S176457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	10	121	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.141inches + 0.005 0.000 - .001	0.146 0.141		ϕ .143
2	Doubler	0.128inches + 0.005 0.000 - .001	0.133 0.128		ϕ .131
3	Doubler	3.857inches $\pm$ 0.010	3.867 3.847		3.857
4	Doubler	17.750inches $\pm$ 0.010	17.760 17.740		17.750
5	Doubler	20.150inches $\pm$ 0.030	20.180 20.120		20.15
6	Doubler	8.500inches $\pm$ 0.010	8.510 8.490		8.505
7	Doubler	1.095inches $\pm$ 0.010	1.105 1.085		1.091
8	Doubler	0.650inches $\pm$ 0.010	0.660 0.640		.656
9	Doubler	0.350inches $\pm$ 0.010	0.360 0.340		.352

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

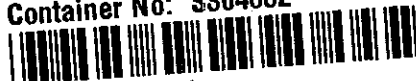
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S304832



Part: D3210-1

Job No: 213320

Serial No/Batch: S304832

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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